

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011520**Date Inspected:** 14-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhu zhong hai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 2G-003 located on PCMK CA3009 of 12CW welder is identified as 201215. ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-TC-U4b-F.

Fit up of following weld joint dimension and tack weld checked with ZPMC QC Mr.Li ming yang and recorded by ZPMC appeared QC to comply with WPS-B-T-2232-TC-U4b-F, the weld is identified as CA3011D-003 of segment 12BW.

STATUS OF SEGMENTS @ OUTSIDE SHOP

Segment 8CE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs of inside and outside completed. ZPMC completed their VT,UT and doing repair on MT indications area.

Segment 8CW

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base

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metal repairs of inside and outside completed. ZPMC completed their VT,UT and MT. Caltrans finished their UT, MT. ZPMC doing welding on CWR locations which found by CT.

Segment 9AE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC completed their UT. ZPMC doing welding on repair locations marked by VT and doing MT.

Segment 9BE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC completed their UT. ZPMC doing welding on repair locations marked by VT.

Segment 9CE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC completed their UT .ZPMC doing welding on repair locations marked by VT.

Segment 9DE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC doing welding on FL3 Stiffener connecting the Edge plate outside.

Segment 9EE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. This segment is ideal.

Segment 9AW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs completed. ZPMC completed their UT .ZPMC doing welding on MT CWR locations by ZPMC.

Segment 9BW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs completed. ZPMC completed their UT .ZPMC doing welding on repair locations marked by VT and doing HSR.

Segment 9CW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC completed their UT. ZPMC doing welding on repair locations marked by VT.

Segment 9DW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC doing welding of Lifting lugs.

Segment 9EW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base

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metal repairs not completed. ZPMC doing welding on repair locations marked by VT.

Segment 7DW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs completed. ZPMC completed their UT. Doing grinding and MT on Deck panel diaphragm @ PP 56, 57 and 58.

Segment 7EW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs completed. ZPMC completed their UT. ZPMC doing welding on repair locations marked by VT and doing their MT.

Segment 8AE

Painted segment, ABF is doing their MT 10% of longitudinal diaphragm, Lifting lugs, deck panel diaphragms welds.

Segment 10AE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. This segment is ideal.

Segment 10BE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. ZPMC doing welding of clips connecting FL1, FL2 to T-ribs.

Segment 10CE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Base metal repairs not completed. This segment is ideal.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
